

50

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	21920
<b>Description:</b> Bracket	<b>Part Number:</b>	D3304-5
<b>Dwg:</b> D3304 Rev. A	<b>Qty:</b>	10
<b>Ref:</b>		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HA	04.11.18	10
2	PG	Issue P/O: <u>2007162</u> <b>Email or Ship DXF file to vendor</b> Laser Cut flat pattern per Dwg D3304 <i>Formed w</i> Possible Supplier: GFI & Industrial Laser <b>Material release note is required</b>	W	04.11.18	10
3	RG	Receive and Inspect for transit damage <b>Ensure material release note is attached</b>	CL	05/01/05	11
4	QC6	Inspect dimensions as per Dwg D3304	Z	05-02-02	10
5	GA	Deburr	SB	05/03/09	10
6	GB	Form as per Dwg D3304	} N/A		
7	GA	Tumble			
8	QC5	Inspect work to Step <u>5</u>	Z	05-04-05	10
9	ST	Identify and Stock	Z	05-04-05	10
10	AC	Cost / part <u>8.21</u>	54C	05-04-06	10
11	DC	Close W/O <u>8.21</u> Inspect Level 21	HA	05-04-12	10

Rev	Date	Change	Revised By	Approved
A	04.09.07	New issue	KJ/JLM	<i>[Signature]</i>

**RELEASED**  
*[Signature]* 04.09.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

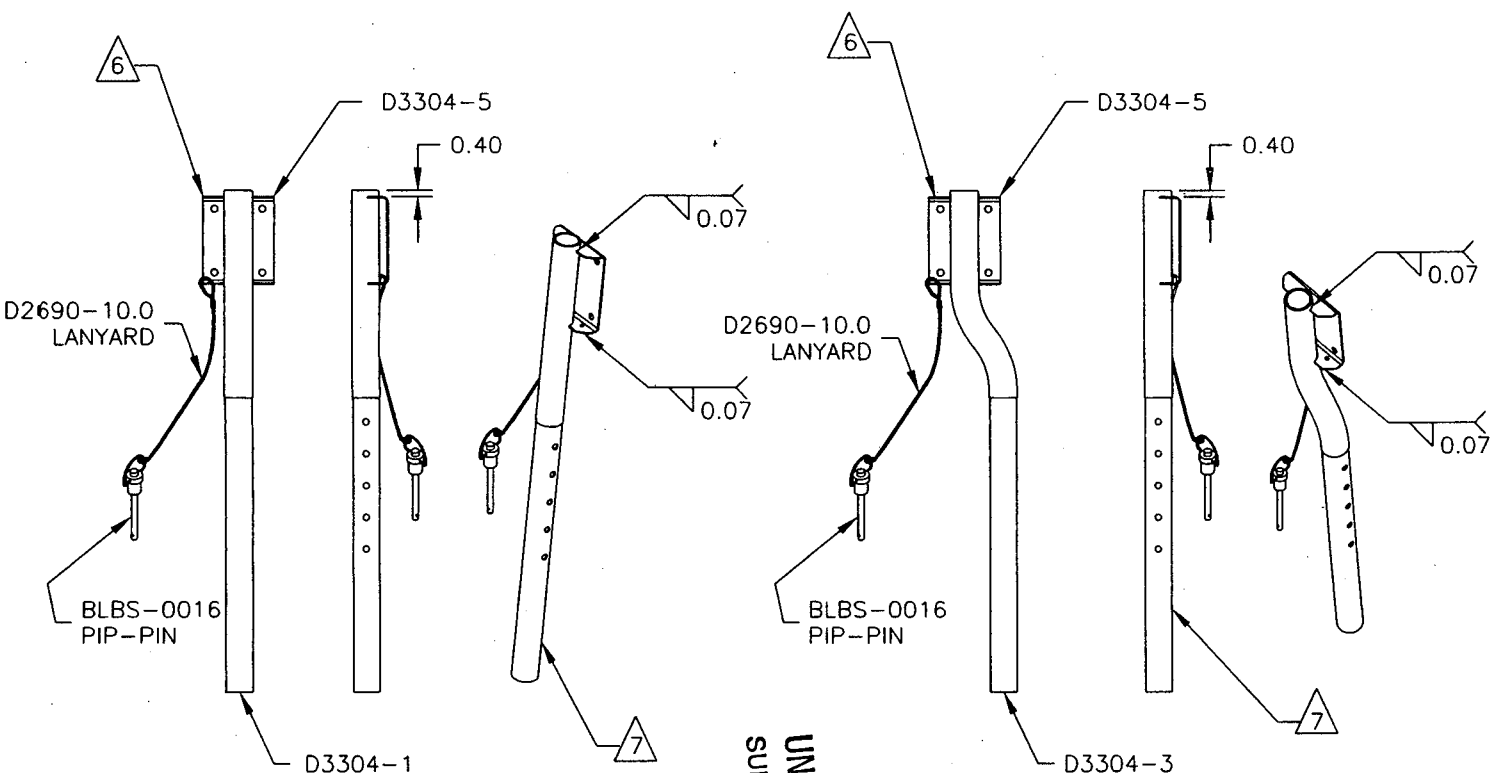
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# DART

DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D3304
DATE	04.08.18	TITLE	TUBE ASSEMBLY	REV. A
A	04.08.18	NEW ISSUE		SHEET 1 OF 4
				SCALE 1:6

**RELEASED**  
04.09.23



**D3304-041 TUBE ASSEMBLY**

**D3304-044 TUBE ASSEMBLY (SHOWN)  
D3304-043 OPPOSITE**

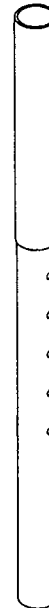
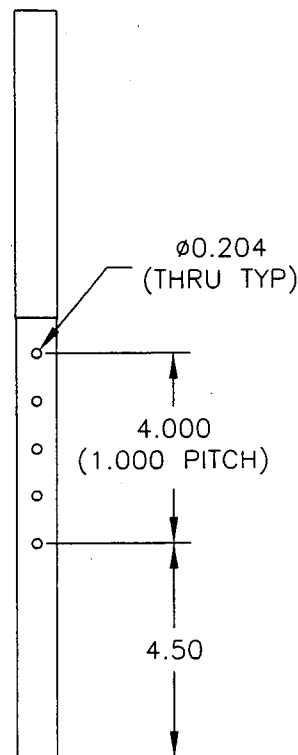
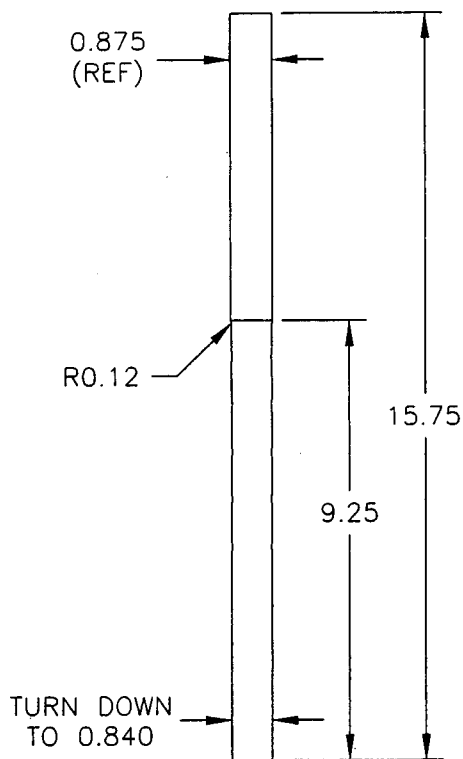
**WORK ORDER  
NO. 21920**  
**SHOCK COPY  
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WITHOUT NOTICE**

**D3304-041/-043/-044 NOTES:**

- 1) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER  
"TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT  
ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT  
PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N  
BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

**DART**

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3304	REV. A SHEET 2 OF 4
DATE 04.08.18	TITLE TUBE ASSEMBLY		SCALE 1:4

**RELEASED**  
04.09.29 LF**D3304-1 TUBE**

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WORK ORDER  
NO. 21920

**D3304-1 NOTES:**

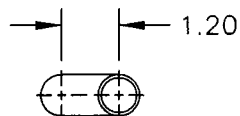
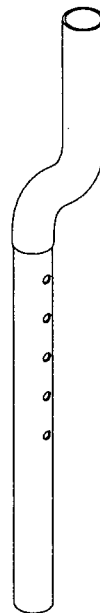
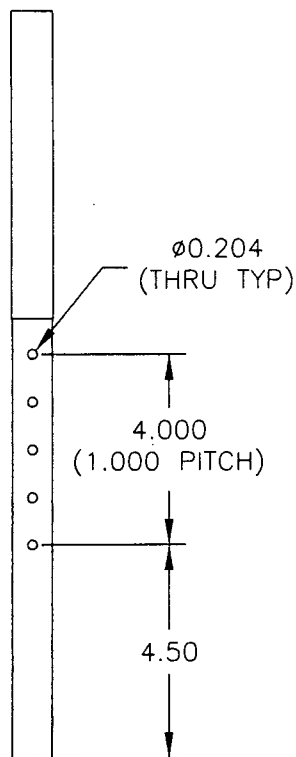
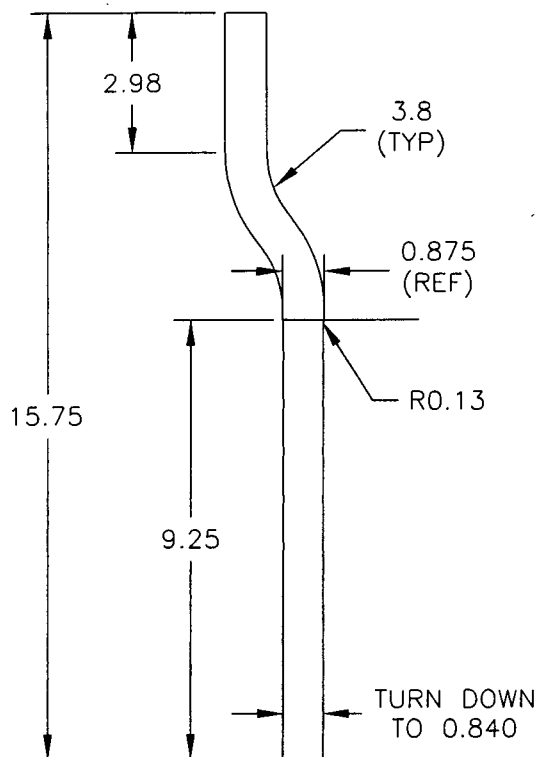
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.875 x 0.065 WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. A SHEET 3 OF 4
DATE 04.08.18	TITLE TUBE ASSEMBLY		SCALE 1:4

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04.09.29 CP

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WORK ORDER  
NO. 21920

**D3304-3 TUBE**



**D3304-3 NOTES:**

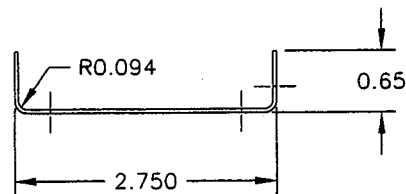
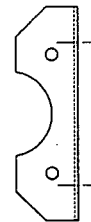
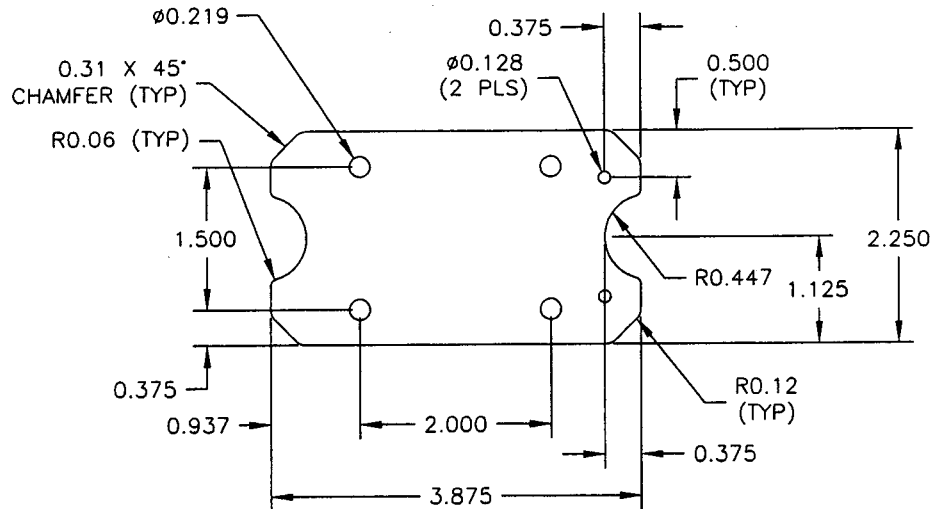
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE  $\phi 0.875 \times 0.065$  WALL  
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3304	REV. A SHEET 4 OF 4
DATE 04.08.18	TITLE TUBE ASSEMBLY		SCALE 1:2

**RELEASED**  
04.09.29 CP**D3304-5 BRACKET**

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WITHOUT NOTICE  
WORK ORDER  
NO. 21920

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 17, 2004  
07:47 am

Work Order No : 0021920  
Project Name : D3304-5  
Project For : WK450  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3304-5  
Description : Bracket  
Manufactured : Yes  
Amount Req'd : 10  
Amount Done : 0  
Start Date : 11-16-04  
Est Finish Date : 12-04-04  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

6/30/3